

Dec 18, 2002
Wednesday

OFA / Plates (SH) extensions

Nelson, Stapp, Hahn,

Tinker Steede (TRZ), Kay ledge (HSB) AI Rep.
Peter Thomas (longman)

26 days to do the work.

1152 SH welds.

Can't Hydro. No time for X-Ray
5% on the OFA ports.

Hartford Steam holds TRZ border stamp.

HSB needs to "okay" the testing procedure.

TRZ R-Stamp?

Border Steam Company of Am + BDA

Tubes - 34JSS, T22 (2 1/4 chrome)

34JSS 20T wall. - Purge

T22 330 wall. - Pre-heat

SH 16 welder per shift

Water Wall 12 welder per shift

Kay X-Ray 2 of 10 first welds. If any failures,
then X-ray all of his welds. IPSC
picks the welder to be checked out.

12-18-82

- Porosity will happen occasionally
- Improper fusion, IP, etc is not acceptable to Tink

Tink: "ChE2 will inspect every weld"

OPA Daysift only 10 hr shift 7 days.
No nightshift. NDE on nightshift
3 or 4 hours everynight for
inspection

4 areas of work.

2-3 ChE2 at platens per shift

1-2 ChE2 in OPA ports per shifts

3-5 → 2 would actually be enough ⇒ Tink.

Nelson: "No plan to hydro the OPA. Too much time."
Doesn't want to spend the time

OPA welds will be TIG root and stick.

Nelson: "In my mind it is respecting the schedule."

Kyo: Not required "M&H"

Nelson "No isolation" of the water wall.

3000 psi in the water wall.

12-18-02

Hydro vs other methods on water wall.

Kay: 50% of working pressure = 1500 psi
of 3000 psi.

Nelson: No way to isolate the water wall.
Air?

Kay: No air → Big bombs.

Radiography?

All welds (OTF) are to be "PT".

Visual all of the welds

RT - spot checks (20%)

PT - a final check → Wet fluorescent mag
is acceptable to AT - Kay.

Hydro

- known areas in fact

- leaks

- Partial stress relief of micro-cracking
can be "checked." (ie eliminate it)

[Hydro testing can reduce the effects of
micro-cracking.]

Platen Tension

- Increased surface area : R2 change.

See 18, 2002

Outage

- Mar 1 Begin Outage
Mar 6 Welding Begins.
Mar 21 Welding Ends.